

Date: Friday, 17/08/2007 11:19:32 AM
User: Linda Lacelle







Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 34066		
Estimate Number	: 12311		
P.O. Number	: N/A	Part Number	: D3471041
This Issue	: 17/08/2007 S.O. No. : N/A	Drawing Number	: D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 28541	Material	: N/A
Written By	: <u>17.08.20</u>	Due Date	: 11/09/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>17.08.20</u>		
Comment	: est rev A 06.03.02 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3471043	SUPPORT AND CLAMP ASSEMBLY
<div><div></div><div></div></div>		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick:		
* 2	part number D3471-043	description CLAMP ASS'Y batch <u>D34083</u>
FF 07-09-10		
2.0	MS20470AD45	Rivet, Universal Head
<div><div></div><div></div></div>		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)		
Pick:		
8	part number MS20470AD4-5	description Rivet batch <u>M104156</u>
FF 07-09-10		
3.0	D34711	BASE
<div><div></div><div></div></div>		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
BASE <u>D26612</u>		
FF 07-09-10		
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<div><div></div><div></div></div>		
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Assemble as per dwg D3471		
FF 07-09-10		
5.0	QC5	INSPECT WORK TO CURRENT STEP
<div><div></div><div></div></div>		
Comment: INSPECT WORK TO CURRENT STEP		
E 21/09/10 (+4)		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:19:32 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 34066

Part Number: D3471041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: _____

7/8/10 (4x) SD

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
D 07/09/11

Job Completion



U 07/09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

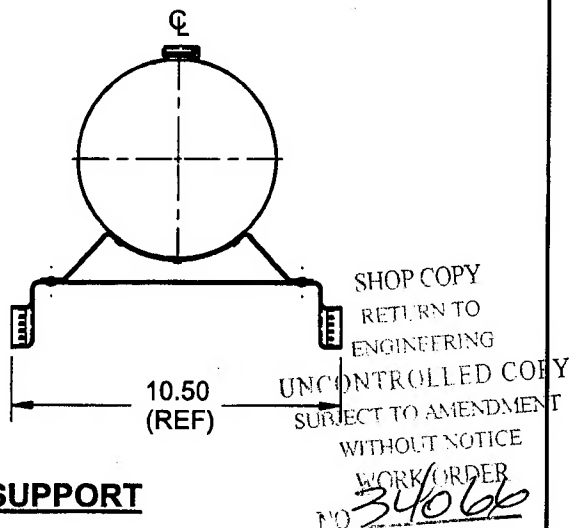
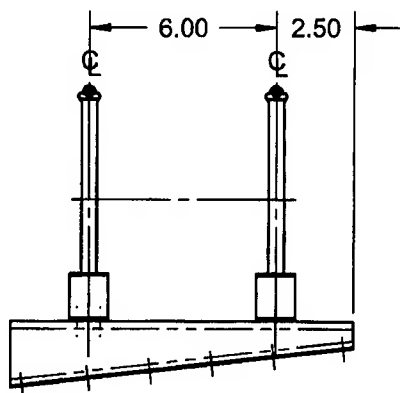
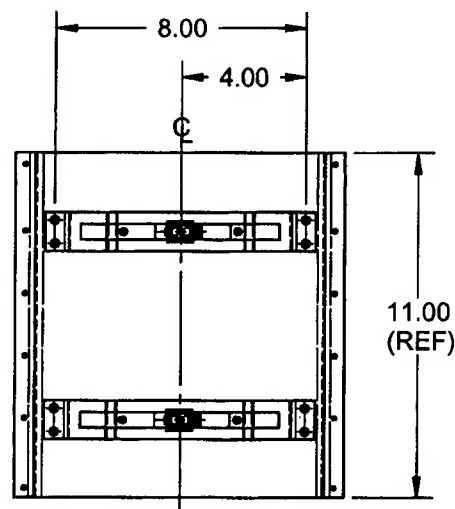
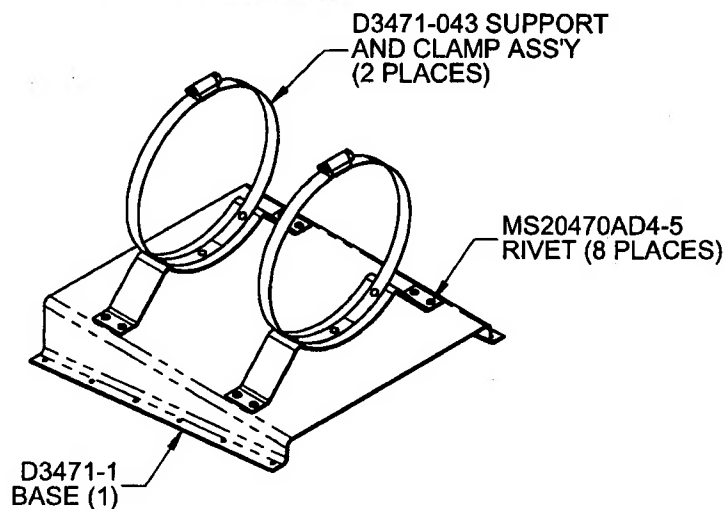
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A SHEET 1 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:6
A	05.12.21	NEW ISSUE	

06-04-03 *[Signature]***D3471-041 BLOWER MOTOR SUPPORT****NOTES:**

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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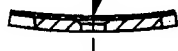
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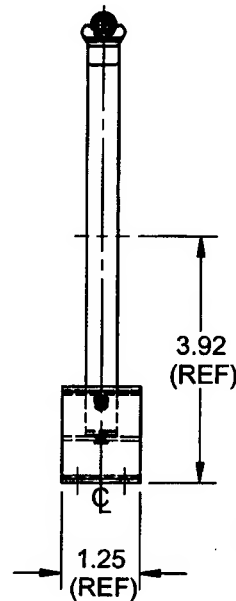
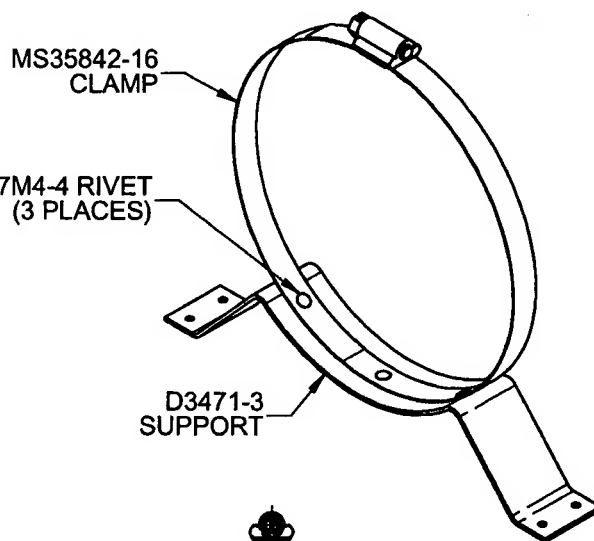
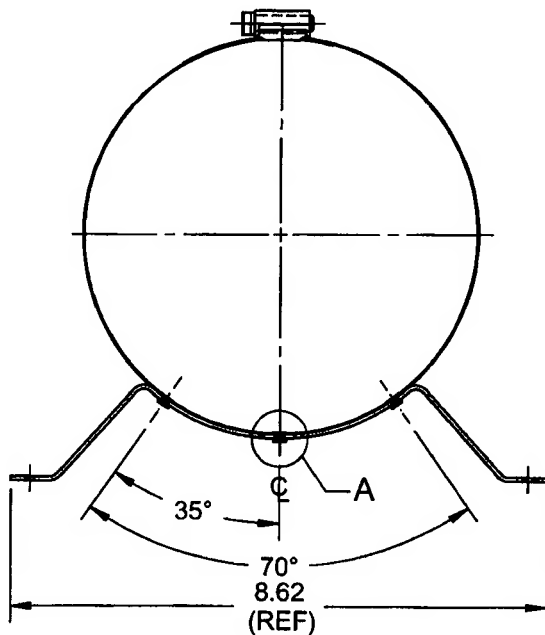
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 2 OF 5 SCALE 1:3

06.04.03 *[Signature]*

LOCATE AND TRANSFER DRILL
#30 ($\phi 0.129$) THRU HOLE FROM
D3471-3 TO MS35842-16 CLAMP
AND C'SINK $\phi 0.230 \times 100^\circ$
(3 PLACES)



DETAIL A: COUNTERSINK HOLES
(RIVET NOT SHOWN FOR CLARITY)
SCALE 1:1



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NO. *34066*

D3471-043 SUPPORT & CLAMP ASS'Y

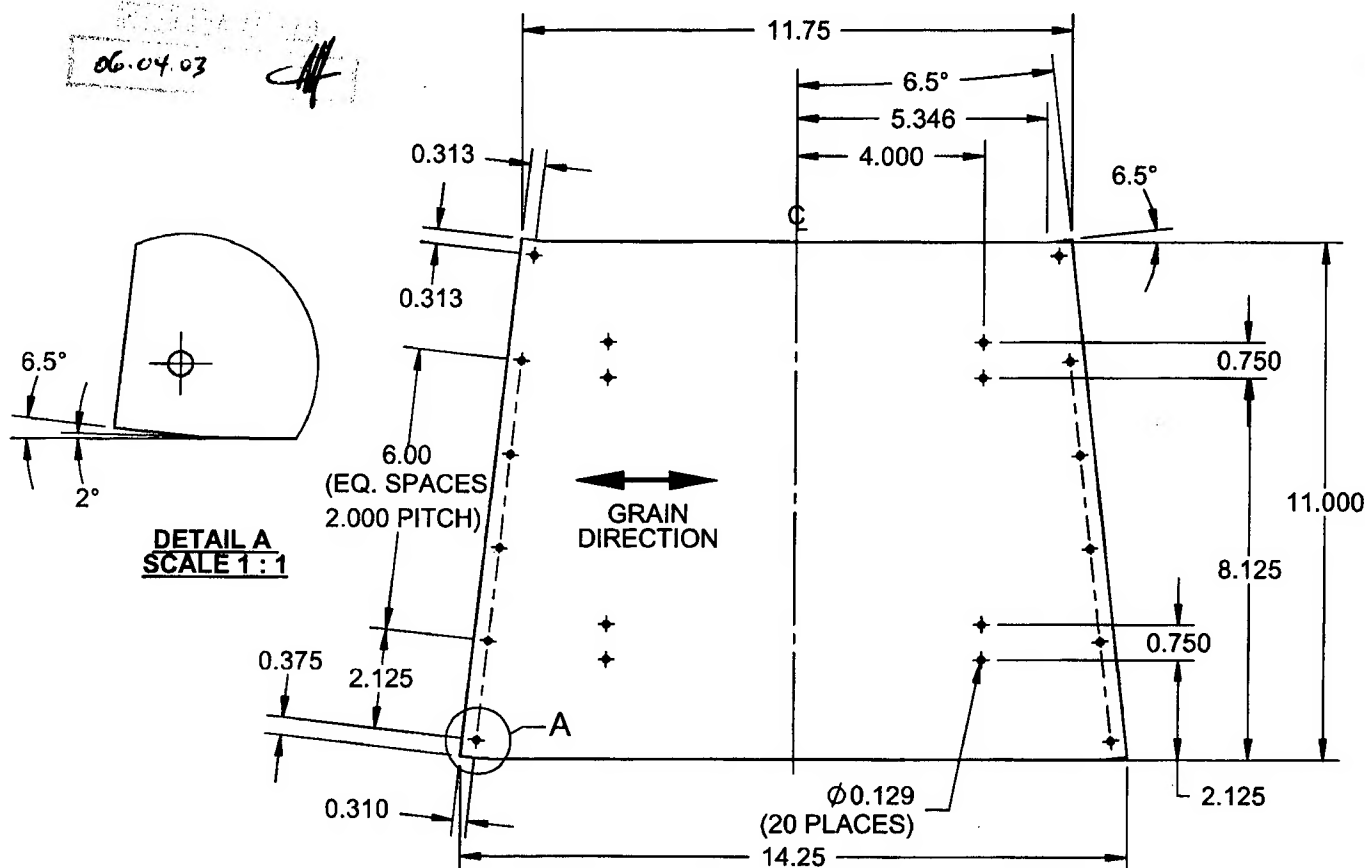
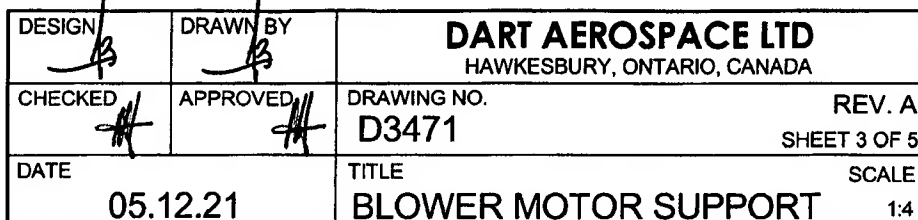
NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

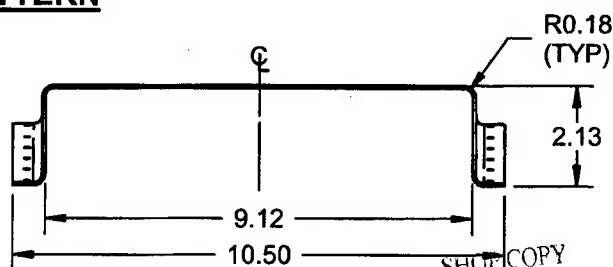
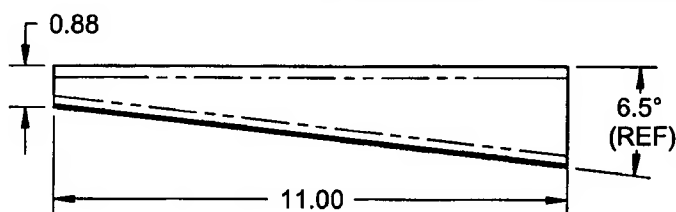
QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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D3471-1F BASE FLAT PATTERN



D3471-1 BASE BENDING DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 NO. 34066
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- WITHOUT NOTICE
WORK ORDER

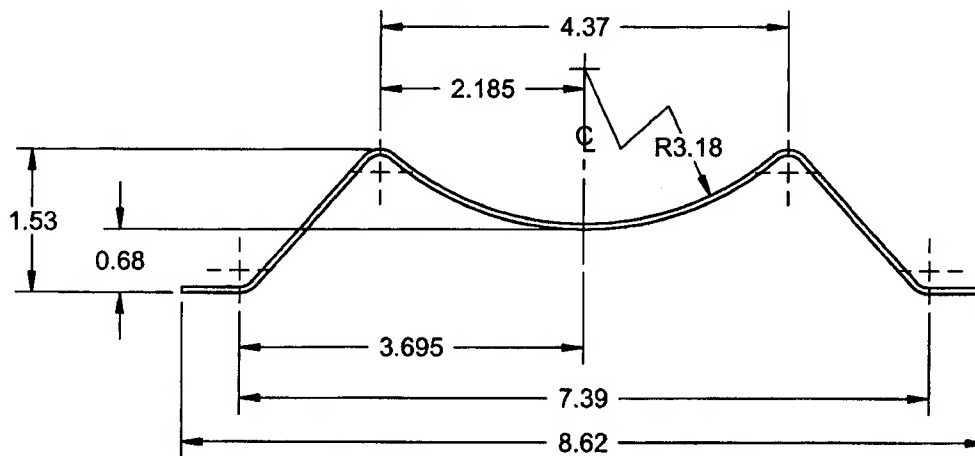
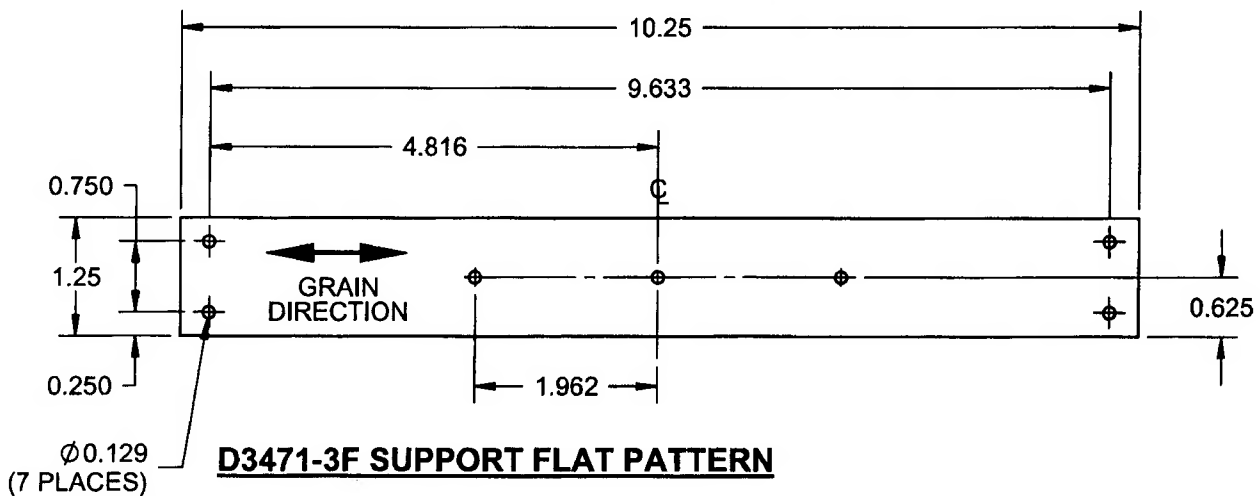
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WORK ORDER
34066

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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2

06-04-03 *[Signature]***NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. *34066*

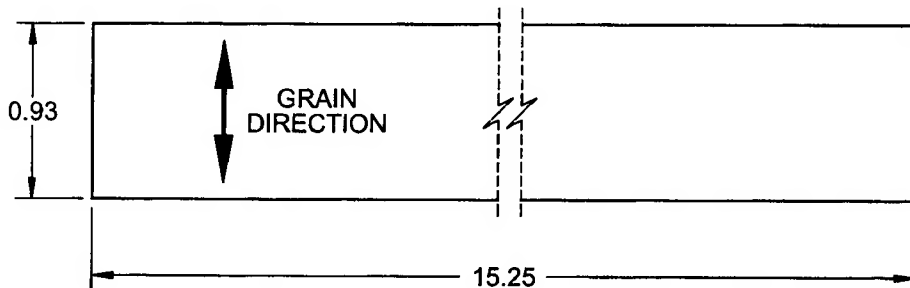
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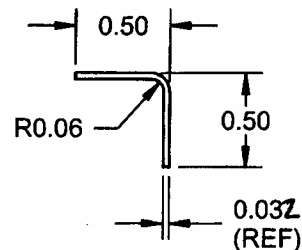


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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1

06.04.03 *[Signature]*



D3471-5F STIFFENER FLAT PATTERN



D3471-5 STIFFENER BENDING DETAIL

D3471-5 STIFFENER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)
PER QQ-A-250/4 OR AMS 4037
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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